

Work Order ID 85102

Friday, June 01, 2012 4:04:18 PM

85102

Page 1

Item ID: PB67-43001-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/1/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MUF*

Date: *12-06-4*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-13	Rev C								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg 3- grind weld flush in area of PB67-43001-249 only 4- install helicol insert as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

12-06-18
FF 12-06-18

BF 12-06-19

Sidhu

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

1 246 12-6-19

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:50
320°F
11:20

1X Ø M-L 12/06/20

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

1X d M nlog/20

Pick Kit

1X SP 12-6-21

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Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

0.00

180

Small Fab

Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support
2- assemble as per dwg

1 0

12-06-25

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1

12/6/25

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

12/6/25

W/O:		WORK ORDER CHANGES					
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Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

210

QC21- Final Inspection - Work Order Release

0.00


210

QC

Memo

0.00

Quality Control

12/6/26 ME
12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, June 01, 2012 4:04:18 PM

Page 1

Work Order ID: 85102

Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec IPP RevC 10.09.27 per RevC
EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67 PB67-43001-67		Manufactured	No		<u>385187</u>	<u>(1)</u>	Each	0.0000		1		6/12/06/18	
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	7.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST438		7							
				52480		7							
PB67-43001-253 Gusset		Manufactured	No		385185	100	Each	0.0000	1	1		6/12/06/18	
PB67-43001-254 Gusset		Manufactured	No		<u>385185</u>	<u>(1)</u>	Each	20.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST438		20							
				52481		20							
PB67-43001-255 Inner Tube		Manufactured	No			100	Each	1.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz		1							
				43071		1							
MS124780 HELICAL INSERT		Purchased	No			180	Each	86.0000	1	1		6/12/06/18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST333		86							
				111064		86							

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

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Parent Item: PB67-43001-13

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-10

Purchased

No

180

Each

126.0000

8

Screw

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

26

120120

26

NASI149D0316J

Purchased

No

180

Each

0.0000

8

Washer

NASI149D0363J

Purchased

No

180

Each

2,183.0000

8

Washer

Location

Loc Qty

Loc Code

ST298

2183

117601

61

118077

1

118612

18

119537

33

120142

13

120308

17

120644

86

121243

494

121524

1460

PB67-43001-69

Manufactured

No

180

Each

3.0000

1

90 Degree Cover Plate

Location

Loc Qty

Loc Code

ST437A

3

52433

3

PB67-43001-83

Manufactured

No

180

Each

11.0000

1

PB67-43001-83

Location

Loc Qty

Loc Code

ST444

11

53240

11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

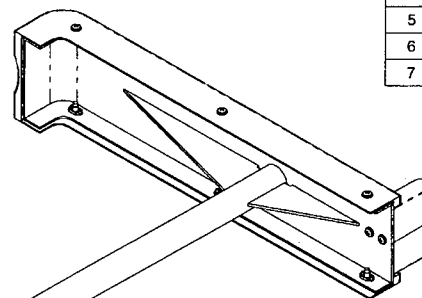
A

D

C

B

A



B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

85102

RELEASED
R 2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	R/V	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. C
MFG. APPR.	5	B67-43001-13	SHEET 1 OF 2
APPROVED	5	TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

8

A

D

C

B

A

B67-43001-11W FWD ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

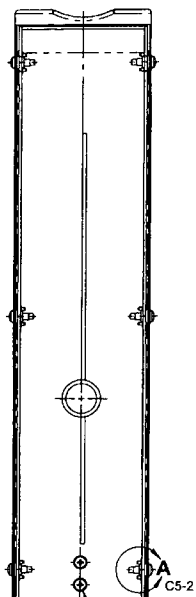
MS27039-1-10 SCREW [8]
NAS1149JD0316J WASHER

B67-43001-69 90-DEGREE
COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-69
90° COVER PLATE ASSEMBLY

B67-43001-13W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT



MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL [8]

#85102

B67-43001-83
D-PAD ASSEMBLY, SHORT

B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.21 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-13W AND B67-43001-83 TO B67-43001-69

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-13	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

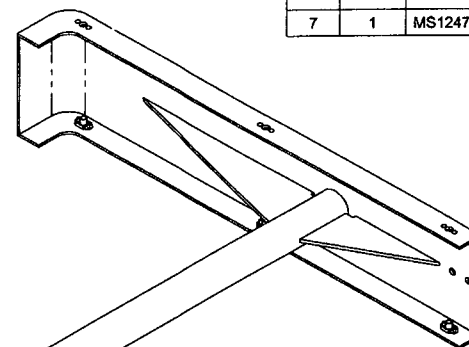
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1	X	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-253	GUSSET
4	1	B67-43001-254	GUSSET
5	1	B67-43001-249	INNER TUBE BUSHING
6	1	B67-43001-255	INNER TUBE
7	1	MS124780	HELICAL INSERT



w/o 85102

B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16
MD

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CHECKED	<i>[Signature]</i>		DRAWING NO. B67-43001-13W REV. C	
MFG. APPR.	<i>[Signature]</i>		SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>		TITLE SCALE	
DE APPR.	N/A		AFT ADJUSTABLE BLADE SUPPORT WELDMENT NTS	
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